

Date: Wednesday, 9/12/2007 12:13:55 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number : 34615	
Estimate Number : 10831	
P.O. Number : <i>N/A</i>	Part Number : D29321
This Issue : 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2932 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34002	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/5/2007 Qty: <i>12</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 2X6.25X7.875  
 Issue material from stock:  
 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length  
 Batch No: *B34644*

*EC* 07.10.07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
 5-Deburr & TUMBLE

*EC* 07.10.07 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

*EC* 07.10.07 (12)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*EC* 07.10.07 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 34615

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/07 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.R. 07/10/09 (12X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 07-10-09 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/10/09 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 07/10/09 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RD 07/10/11 (12)

Job Completion



LL 07-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34615
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.122	.123	.123		
B	0.100	0.140		.122	.123	.123	.123		
C	0.100	0.140		.120	.114	.120	.115		
D	0.210	0.230		.228	.226	.226	.224		
E	1.245	1.255		1.247	1.249	1.250	1.250		
F	1.245	1.255		1.249	1.248	1.250	1.250		
G	2.495	2.505		2.500	2.501	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.516		
I	1.572	1.582		1.576	1.579	1.579	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.126	.127	.128	.127		
O	0.540	0.560		.550	.551	.550	.547		
P	0.490	0.510		.508	.506	.500	.500		
Q	3.715	3.725		3.717	3.718	3.720	3.716		
R	2.470	2.510		2.500	2.502	2.498	2.497		
S	0.240	0.270		.253	.253	.253	.250		
T	0.100	0.180		.146	.140	.142	.138		
U	1.625	1.635		1.630	1.629	1.631	1.630		
V	1.362	1.372		1.368	1.367	1.369	1.365		
W	0.316	0.321		.321	.321	.320	.320		
X	1.125	1.145		1.130	1.130	1.138	1.139		
Y	1.565	1.585		1.570	1.570	1.578	1.579		
Z	0.178	0.198		.184	.188	.188	.184		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F. RF
Date: 07/10/07

Audited by: J.F.
Date: 07/10/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34615
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.120	.120	.120	.120		
B	0.100	0.140		.121	.121	.121	.121		
C	0.100	0.140		.129	.119	.49	.119		
D	0.210	0.230		.226	.227	.227	.227		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.579	1.579	1.579	1.579		
J	2.495	2.505		2.499	2.500	2.501	2.500		
K	0.257	0.262		.257	.257	.257	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.127	.128	.128	.127		
O	0.540	0.560		.551	.546	.546	.546		
P	0.490	0.510		.495	.495	.495	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.501	2.496	2.500	2.500		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.631	1.631	1.630	1.630		
V	1.362	1.372		1.365	1.368	1.369	1.365		
W	0.316	0.321		.320	.319	.320	.319		
X	1.125	1.145		1.139	1.140	1.140	1.140		
Y	1.565	1.585		1.579	1.580	1.580	1.580		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F. 1RG	Audited by: J.F.
Date: 07/20/05	Date: 07/10/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34615</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2932-1</b>
<b>Inspection Dwg:</b> D2932 Rev. C		<b>Page 1 of 1</b>

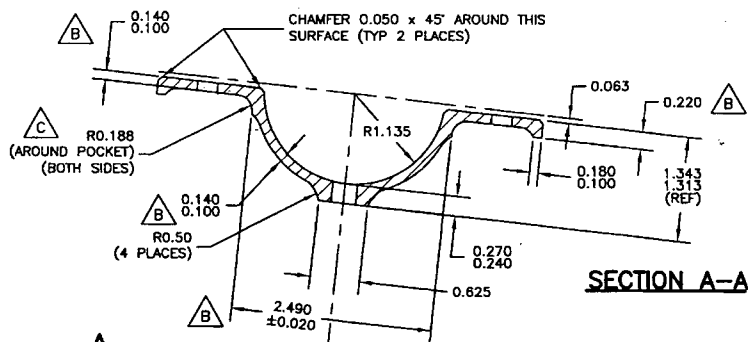
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 <sub>9</sub>	2 <sub>10</sub>	3 <sub>11</sub>	4 <sub>12</sub>		
A	0.100	0.140		.120	.120	.120	.120		
B	0.100	0.140		.121	.121	.121	.121		
C	0.100	0.140		.119	.119	.119	.119		
D	0.210	0.230		.227	.227	.227	.227		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.127	.127	.127	.127		
O	0.540	0.560		.545	.546	.546	.546		
P	0.490	0.510		.495	.495	.495	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.365	1.365	1.365	1.365		
W	0.316	0.321		.319	.319	.319	.319		
X	1.125	1.145		1.140	1.140	1.140	1.140		
Y	1.565	1.585		1.580	1.580	1.580	1.580		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

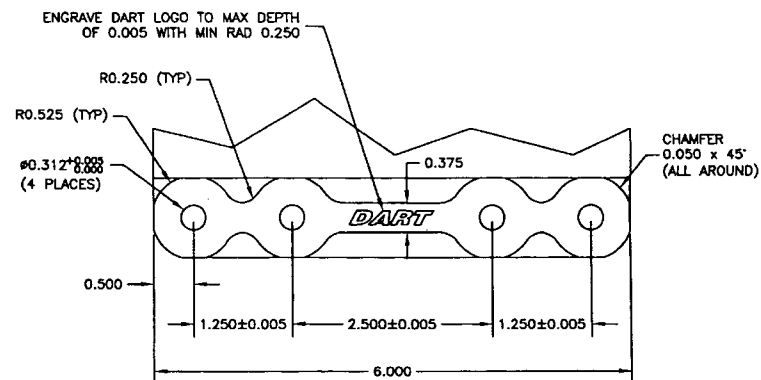
Measured by:	<b>SG</b>
Date:	<b>07.10.06</b>

Audited by:	<b>J.F.</b>
Date:	<b>07/10/07</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A



VIEW C-C

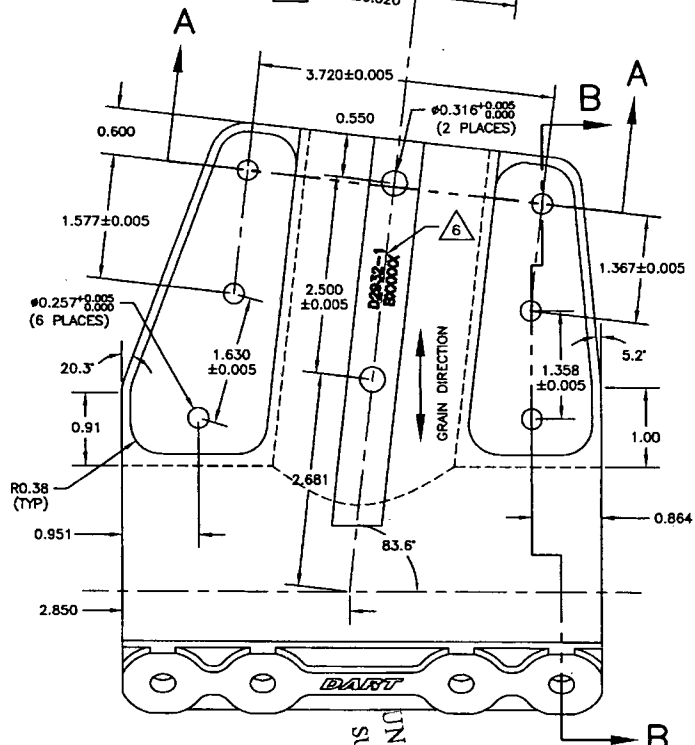
D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

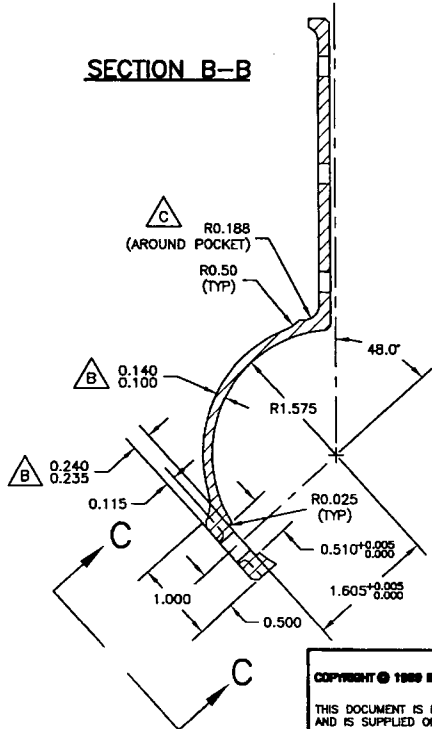
C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY <i>AH</i>	DRAWN BY <i>CB</i>
CHECKED	<i>AH</i>	APPROVED <i>AH</i>
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

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SECTION B-B



RELEASED  
07-02-12

NO. 34615  
WORK ORDER  
SUBJECT TO ADJUSTMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY